

Date: Tuesday, 8/28/2007 3:23:09 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 34316	
Estimate Number : 12737	
P.O. Number : <i>N/A</i>	Part Number : D353513
This Issue : 8/28/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 UNDER REVIEW <i>Rev B 07/08/31</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32268	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/14/2007 Qty: 20 Um: Each
Checked & Approved By : <i>07/08/28</i>	
Comment : Est Rev-A New Issue 07-02-15 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8930 sf(s)/Unit Total : 17.8605 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M105130*

*SAD*

*07/08/31*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*IB 07-09-12*

*SAD 07/08/31*

*20*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/08/31*

*20*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*En 07/09/12*

*counted (x20)*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

*SB 07/09/25*

*(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/09/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:23:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34316

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*fr 468/25 (20) combs*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m 104846*

*FL 07/09/26*

*(20)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*W 07-09-27*

*(20)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *FR-15*

*FL 07/09/27*

*(20)*

*(20)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*DO 07/09/28*

Job Completion



*u 07.09.28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

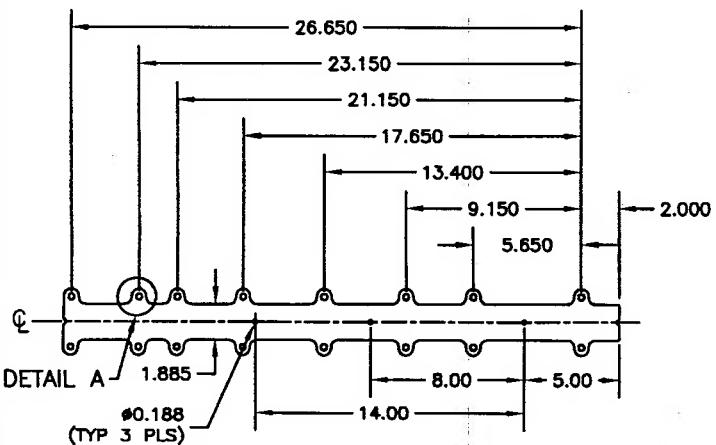
NOTE: Date & initial all entries

**DART**

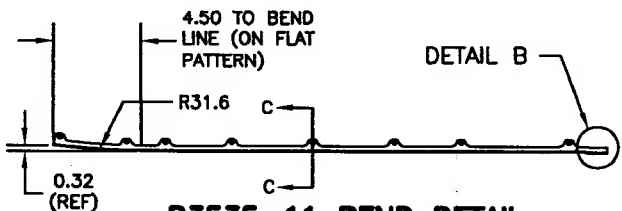
RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

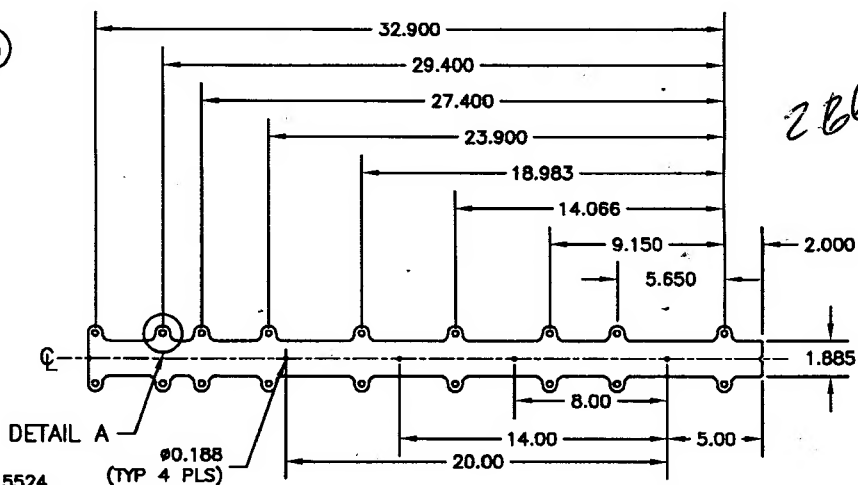


**D3535-11F FLAT PATTERN**

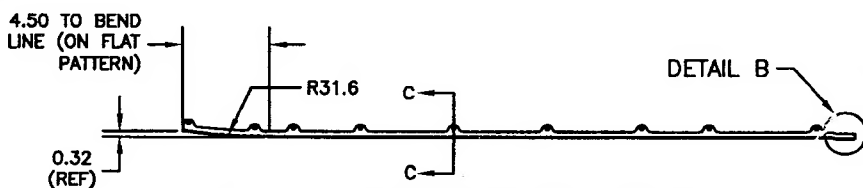


**D3535-11 BEND DETAIL**

NO. *34314*  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

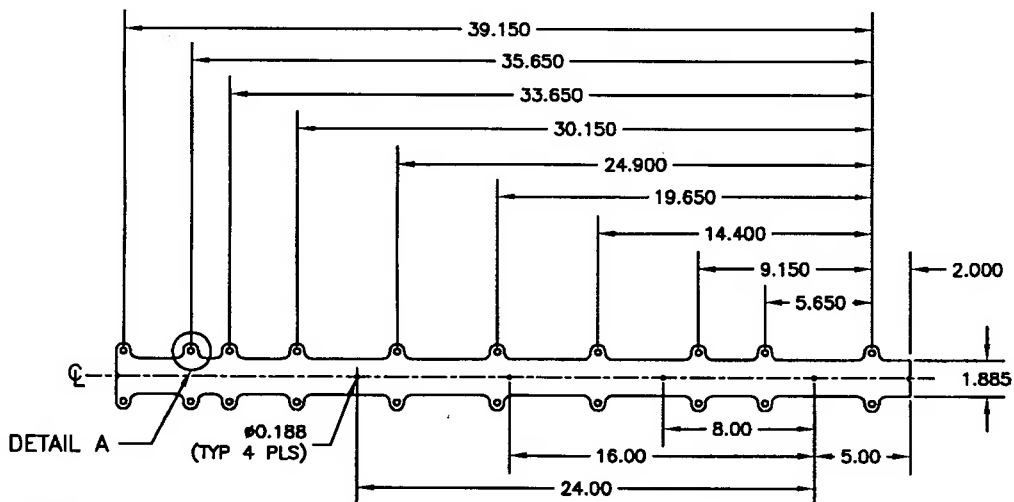
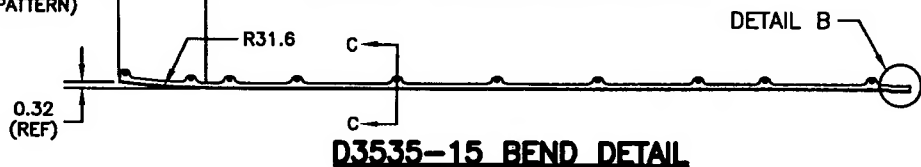
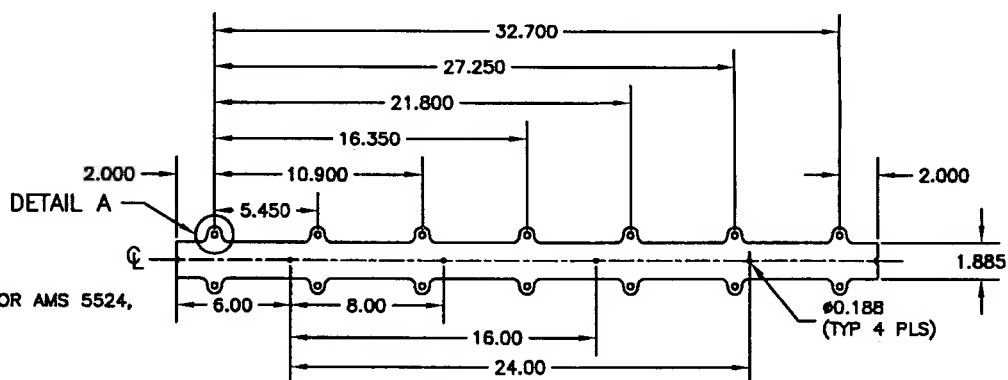
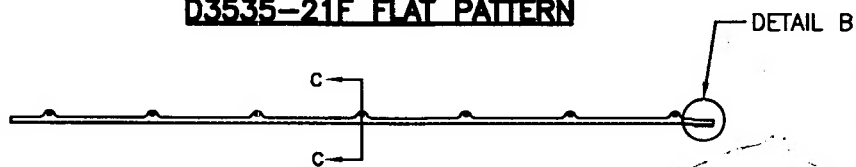
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

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CHECKED	APPROVED	D3535	SHEET 2 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

4.50 TO BEND  
LINE (ON FLAT  
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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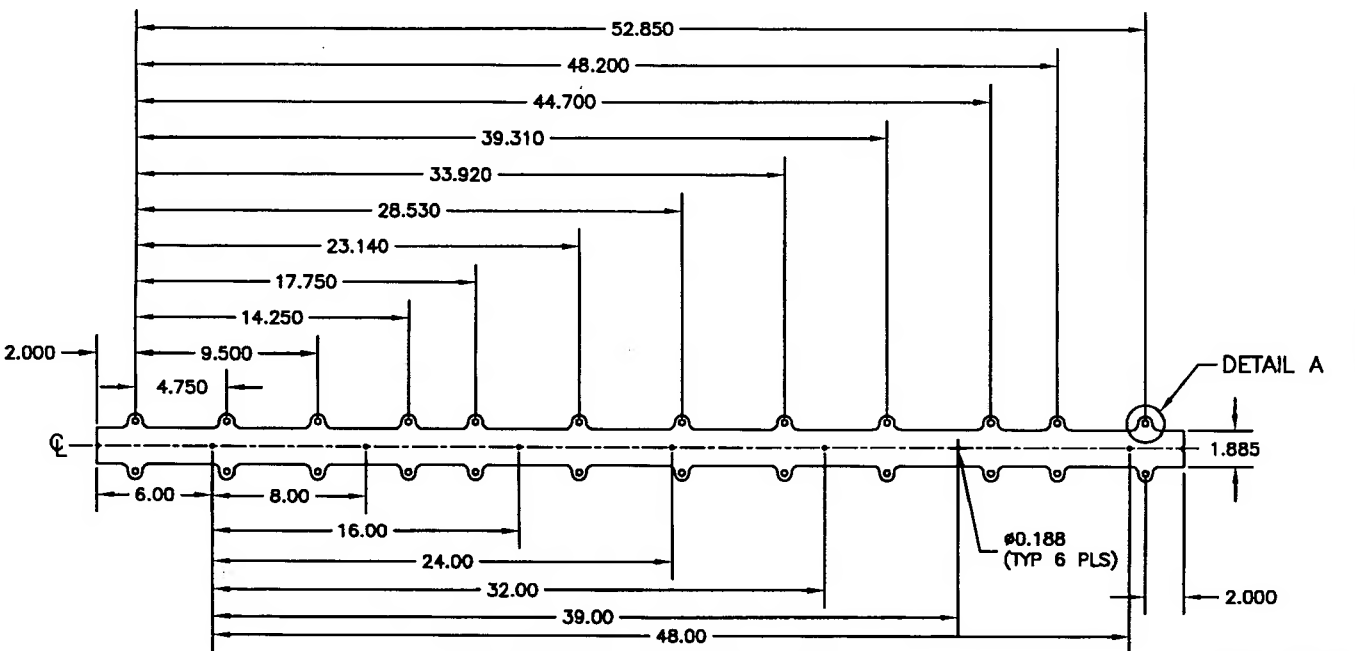
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WORK ORDER  
NO. 34316

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<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 3 OF 7	
DATE	TITLE	SCALE		
07.04.17	WEARSHOE	1:10		

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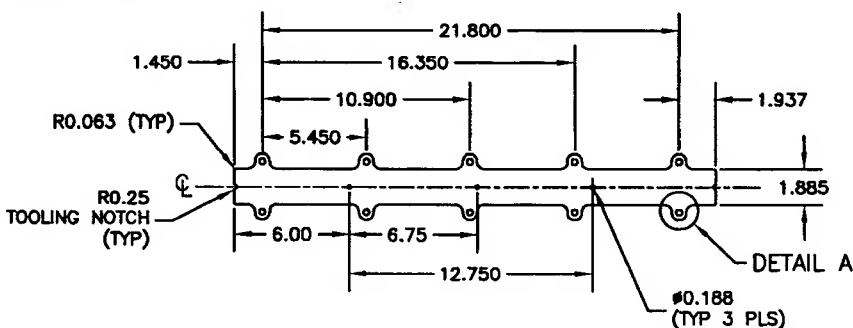
07.04.24



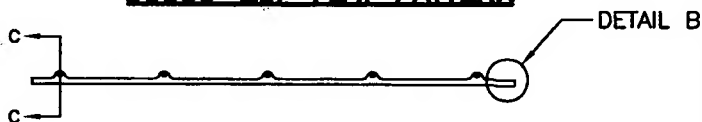
**D3535-23F FLAT PATTERN**



**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**



**D3535-25 BEND DETAIL**

**NOTES**

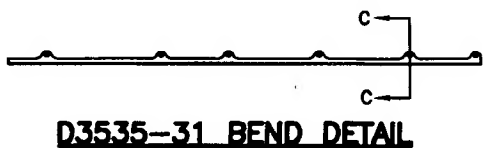
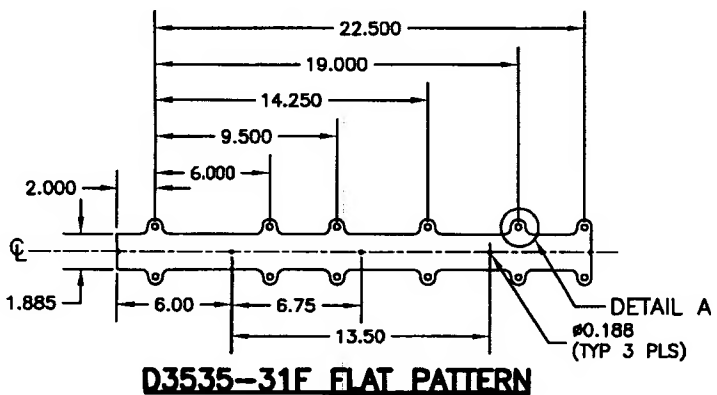
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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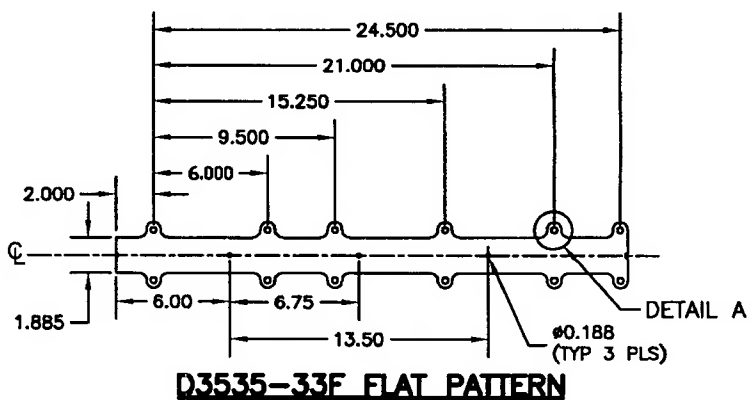
07.04.24



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WORK ORDER  
NO. 34316

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	

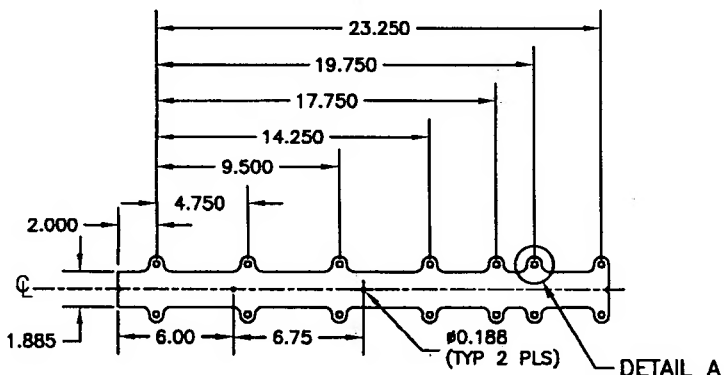


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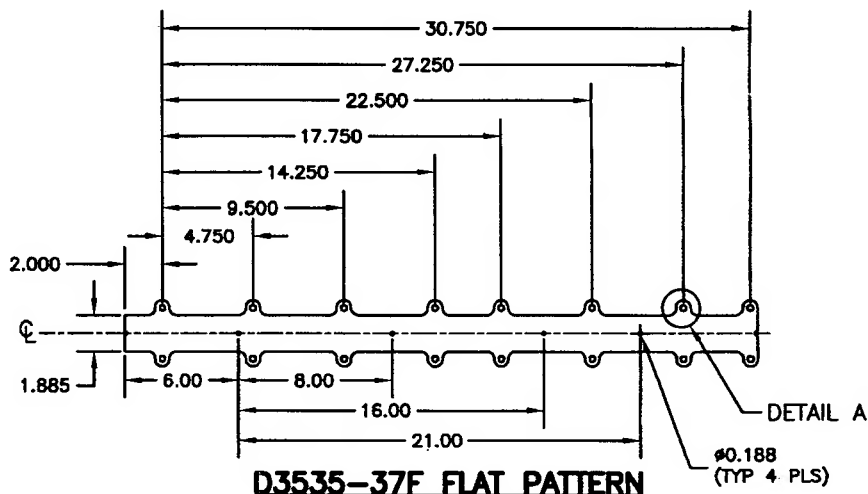
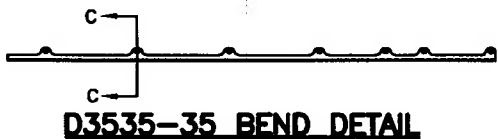
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



**D3535-35F FLAT PATTERN**



**D3535-37F FLAT PATTERN**



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WORK ORDER  
NO. 24316

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**DESIGN  
**CB**DRAWN BY  
**PH**DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

CHECKED

APPROVED

DRAWING NO.

REV. B

DATE

TITLE

SHEET 6 OF 7

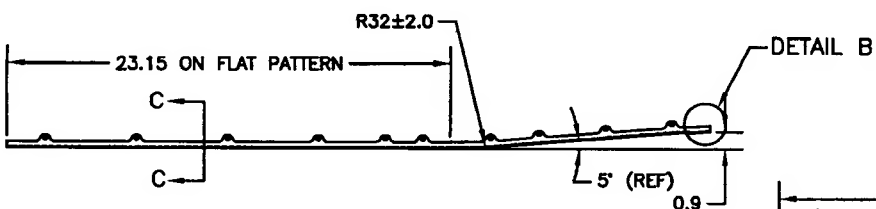
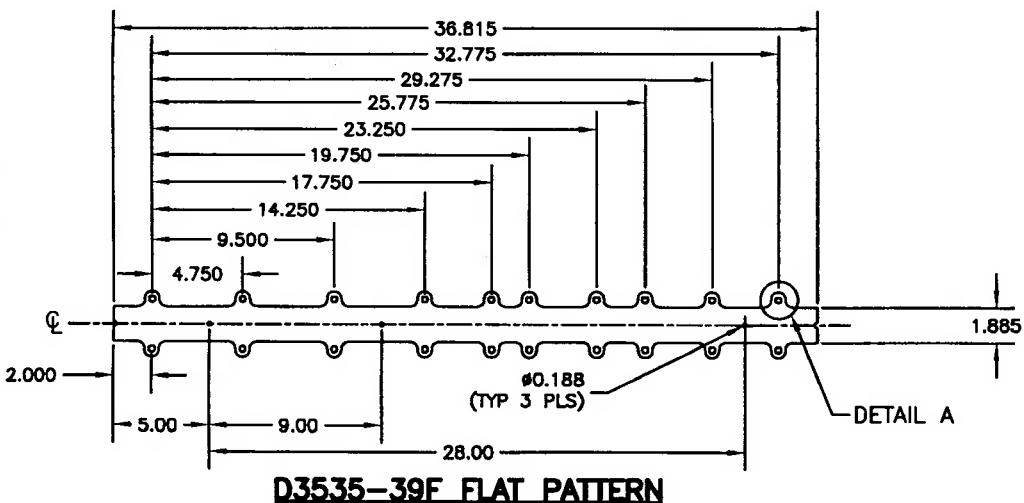
07.04.17

WEARSHOE

1:10

RELEASED

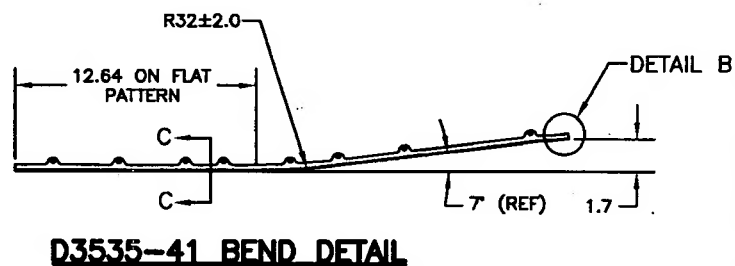
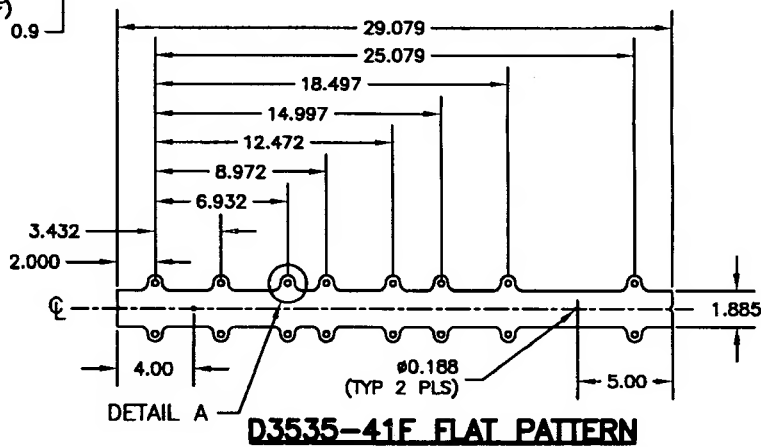
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WORK ORDER  
NO. 34316

**NOTES**

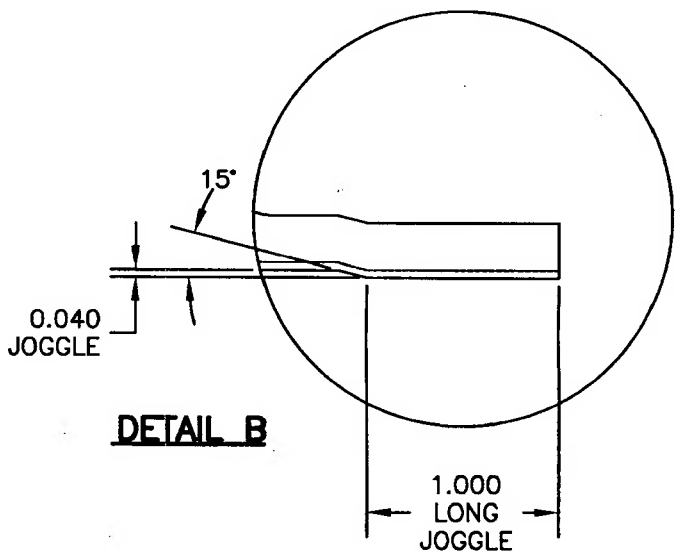
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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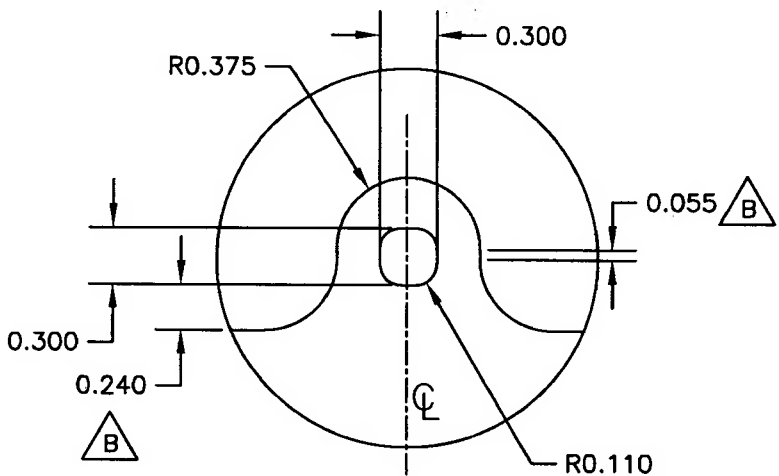


DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
C.B.	MH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 7 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:1	

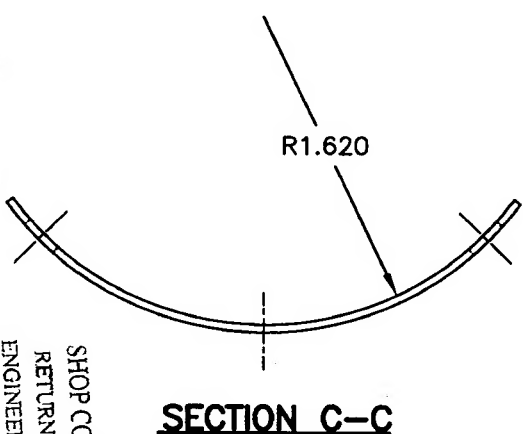
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07.04.24



DETAIL B



DETAIL A



SECTION C-C

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WITHOUT NOTICE

WORK ORDER  
NO. 34316

DART AEROSPACE LTD		Work Order: 34316
Description: WEARSHOE		Part Number: D353513
Inspection Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.900	+/- 0.010	32.900	✓		M-T	
29.400	+/- 0.010	29.300	✓		M-T	
27.400	+/- 0.010	27.400	✓		M-T	
23.900	+/- 0.010	23.900	✓		M-T	
18.983	+/- 0.010	18.990	✓		M-T/Vern	
14.066	+/- 0.010	14.062	✓		<del>M-T</del> Vern	
9.150	+/- 0.010	9.155	✓		Vern	
5.650	+/- 0.010	5.652	✓		Vern	
Ø 0.188	EL +0.005 <del>0.000</del>	Ø 0.191	✓		Vern	
20.000	+/- 0.010	20.000	✓		M-T	
14.000	+/- 0.010	15.000	✓		M-T	
8.000	+/- 0.010	8.000	✓		M-T	
1.885	+/- 0.010	1.884	✓		Vern	
2.665	+/- 0.010	2.666	✓		Vern	
0.038	+/- 0.010	0.033	✓		Vern	
0.300	+/- 0.010	0.300	✓		Vern	
0.300	+/- 0.010	0.300	✓		Vern	

Measured by: SAN	Audited by: Er	Prototype Approval: N/A
Date: 07/08/31	Date: 07/09/04	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	